

We Claim:

Dab A 1. A print-receptive, pill-resistant, knitted fabric, said fabric knitted from
yarn formed from high-tenacity, staple synthetic fiber having a tenacity value of greater
5 than about 4 grams/denier, wherein said knitted fabric has a pilling resistance value of
greater than about 3.

2. The knitted fabric of claim 1, wherein said knitted fabric is a double-knit
fabric having a front side and a back side, the front side being formed from said high-
10 tenacity, staple synthetic fiber and the back side being substantially formed from
cellulosic yarn, said cellulosic yarn being selected from the group consisting of cotton
and synthetic cellulosic fibers.

f. 2 15 The knitted fabric of claim 1, wherein the back side of said fabric is
substantially 100% spun cotton fiber.

f. 3 20 The knitted fabric of claim 1, wherein the front side and back side of said
fabric are a single jersey knit construction.

f. 4 25 The knitted fabric of claim 1, further including a tie yarn between the *front*
and back of said fabric.

f. 5 30 The knitted fabric of claim 1, wherein the high-tenacity, staple synthetic
fiber has a tenacity of about 6 grams/denier.

Dab 25 7. A print-receptive, pill-resistant, knitted fabric, said fabric knitted from
yarn formed from high-tenacity, staple synthetic fiber having a tenacity value of greater
than about 4 grams/denier, wherein said knitted fabric has a pilling resistance value of
greater than about 3, and said high-tenacity, staple synthetic fiber is selected from the
30 group consisting of air jet spun polyester; nylon; acrylic; and polypropylene.

8. The knitted fabric of claim 7, wherein said high-tenacity, staple synthetic
fiber is polyester.

9. The knitted fabric of claim 7, wherein said high-tenacity, staple synthetic fiber has a denier of less than about 1.5.

a 5 10. The knitted fabric of claim 9, wherein said high-tenacity, staple synthetic fiber has a denier of about 1.

11. The knitted fabric of claim 7, wherein the staple length of said high-tenacity, synthetic fiber is about 1.5 inches.

10 12. The knitted fabric of claim 11, wherein the staple length of said high-tenacity, synthetic fiber is variable up to about 1.5 inches.

13. A print-receptive, pill-resistant, knitted fabric, said fabric knitted from
15 yarn formed from high-tenacity, staple synthetic fiber, having a tenacity value of greater
than about 4 grams/denier, wherein said knitted fabric has a pilling resistance value of
greater than about 3, and said high-tenacity, staple synthetic fiber is selected from the
group consisting of air jet spun polyester; nylon; acrylic; and polypropylene, and wherein
20 said knitted fabric is a double-knit fabric having a front side and a back side, the front
side being formed from said high-tenacity, staple synthetic fiber and the back side being
substantially formed from cellulosic yarn, said cellulosic yarn being selected from the
group consisting of cotton and synthetic cellulosic fibers.

14. 7 The knitted fabric of claim 13, wherein the back side of said fabric is
25 substantially 100% spun cotton fiber.

15. 8 The knitted fabric of claim 13, 6 wherein the front side and back side of said
fabric are a single jersey knit construction.

30 16. 9 The knitted fabric of claim 13, 6 further including a tie yarn between the
front face and back of said fabric.

17¹⁰ The knitted fabric of claim 13⁶, wherein the high-tenacity, staple synthetic fiber has a tenacity of about 6 grams/denier.

18¹¹ The knitted fabric of claim 13⁶, wherein said high-tenacity, staple synthetic fiber is polyester.⁵

19¹² The knitted fabric of claim 13⁶, wherein said high-tenacity, staple synthetic fiber has a denier of less than about 1.5.

20¹³ The knitted fabric of claim 19¹², wherein said high-tenacity, staple synthetic fiber has a denier of about 1.¹⁰

21¹⁴ The knitted fabric of claim 13⁶, wherein the staple length of said high-tenacity, synthetic fiber is about 1.5 inches.¹⁵

22¹⁵ The knitted fabric of claim 21¹⁴, wherein the staple length of said high-tenacity, synthetic fiber is variable up to about 1.5 inches.¹⁴

23²⁰ A printed, pill-resistant, article of apparel, said article of apparel knitted from yarn formed from high-tenacity, staple synthetic fiber having a tenacity value of greater than about 4 grams/denier, wherein said article of apparel has a pilling resistance value of greater than about 3.

24²⁵ A printed, pill-resistant, article of apparel, said article of apparel knitted from yarn formed from high-tenacity, staple synthetic fiber having a tenacity value of greater than about 4 grams/denier, wherein said article of apparel has a pilling resistance value of greater than about 3, and said high-tenacity, staple synthetic fiber is selected from the group consisting of air jet spun polyester; nylon; acrylic; and polypropylene.²⁵

25³⁰ A printed, pill-resistant, article of apparel, said article of apparel knitted from yarn formed from high-tenacity, staple synthetic fiber having a tenacity value of greater than about 4 grams/denier, wherein said article of apparel has a pilling resistance value of greater than about 3, and said high-tenacity, staple synthetic fiber is selected

from the group consisting of air jet spun polyester; nylon; acrylic; and polypropylene, and wherein said article of apparel is formed from a double-knit fabric having a front side and a back side, the front side being formed from said high-tenacity, staple synthetic fiber and the back side being substantially formed from cellulosic yarn, said cellulosic 5 yarn being selected from the group consisting of cotton and synthetic cellulosic fibers.

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